

538

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 34127
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b> D3195-1
4.02.23 <del>4.02.23</del>		<b>Qty:</b> 30 Kit(s)
<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A1		<b>Page 1 of 4</b>
<b>Ref:</b> D412-702 Rev.A page 9		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note:</b> D412-702-011 Kit consists of (2) D3195-041; (2) D3195-043; (1) D3196-1; (1) D3196-3; (1) D3196-4; (2) D3197-041.	U	05/08/31	30
2	DC	Photocopy bluefile and create labels per PPP D412-702-011 CHG001	DH	05/09/09	30
3	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (0.75" x 2.00") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B0.750x02.000) <b>Identify for D3195-1</b> Batch: 110138	mg	05/08/31	30
4	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (1.50" x 1.25") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.500x01.250) <b>Identify for D3195-3</b> Batch:			
5	MV	Cut blank: (0.75" x 1.50") x 26.200" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) <b>Identify for D3196-1</b> Batch:	N/A	U	
6	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (0.75" x 1.50") x 34.750" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) <b>Identify (1) for D3196-3</b> <b>Identify (1) for D3196-4</b> Batch:			
7	MV	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: 29.125" long Round Bar Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD (M7075T73R1.000) <b>Identify for D3197-1</b> Batch:			
8	MV	Machine D3195-1 as per Folio FA334 and Dwg D3195 <b>Identify as D3195-1</b>	SD	05.09.02	30
9	QC2	Inspect parts as they come off the CNC machine	SD	05.09.02	30
10	MV	Deburr and Tumble	SD	05.09.02	30
11	QC8	Second check	BG	05.09.07	30
12	MV	Machine D3195-3 as per Folio FA334 and Dwg D3195 <b>Identify as D3195-3</b>			
13	QC2	Inspect parts as they come off the CNC machine	N/A	U	
14	MV	Deburr and Tumble			
15	QC8	Second check			

RELEASE

04.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 05/10/06

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24127
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b>	D3195-1 D412-702-011
Dwg: D3195 Rev. A; D3196 Rev. A; D3197 Rev. A		<b>Qty:</b>	30 Kit(s)
Ref: D412-702 Rev.A page 9			Page 2 of 4

Step	Location	Procedure	By	Date	Qty
16	MV	Machine D3196-1 as per Folio FA339 and Dwg D3196 <b>Identify as D3196-1</b>			
17	QC2	Inspect parts as they come off the CNC machine			
18	MV	Deburr			
19	QC8	Second check			
20	MV	Machine D3196-3 as per Folio FA339 and Dwg D3196 <b>Identify as D3196-3</b>			
21	QC2	Inspect parts as they come off the CNC machine			
22	MV	Deburr			
23	QC8	Second check			
24	MV	Machine D3196-4 as per Folio FA339 and Dwg D3196 <b>Identify as D3196-4</b>			
25	QC2	Inspect parts as they come off the CNC machine			
26	MV	Deburr			
27	QC8	Second check			
28	MV	Machine D3197-1 as per Folio FA340 and Dwg D3197 <b>Note: Need to be faced to size</b> <b>Identify as D3197-1</b>			
29	QC2	Inspect parts as they come off the CNC machine			
30	MV	Deburr			
31	QC8	Second check			
32	FP	Chemical Conversion Coat as per QSI 005 4.1 D3195-1/-3; D3196-1/-3/-4; D3197-1	ML	05-03-21	30
33	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3195-1/-3; D3196-1/-3/-4; D3197-1	FC	05-09-21	30
34	QC3	Inspect work to Step 33.		05-09-23	30
35	GA JTF 04-04-05	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (4.986" x 0.500") x 0.125" thick as per Dwg D3195 Material: D3195 Rubber 2.500" Punch holes as per Dwg <b>Identify as D3195-5</b> Batch: B28359 M16194		05/09/24	30
36	GA JTF 04-04-05	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (4.986" x 1.000") x 0.125" thick as per Dwg D3195 Material: D3195 Rubber 2.500" Punch holes as per Dwg <b>Identify as D3195-7</b> Batch:		N/A	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24127
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b>	D3195-1 D412-702-011
04.02.23 <del>14</del>			
<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A1		<b>Qty:</b>	30 Kit(s)
<b>Ref:</b> D412-702 Rev.A page 9			Page 3 of 4

Step	Location	Procedure	By	Date	Qty																																																																				
37	GA	Bond D3195-5 into D3195-1 as per Dwg D3195 <b>Pick:</b> <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>A/R</td> <td>Contact Cement</td> <td>M16194</td> </tr> </table> <b>Identify as D3195-041</b>	<u>Qty</u>	<u>Description</u>	<u>Batch</u>	A/R	Contact Cement	M16194	SB	08/09/27	30																																																														
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A/R	Contact Cement	M16194																																																																							
38	GA	Bond D3195-7 into D3195-3 as per Dwg D3195 <b>Pick:</b> <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>A/R</td> <td>Contact Cement</td> <td></td> </tr> </table> <b>Identify as D3195-043</b>	<u>Qty</u>	<u>Description</u>	<u>Batch</u>	A/R	Contact Cement		N/A																																																																
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A/R	Contact Cement																																																																								
39	QC5	Inspect work to Step 38		05-10-03	30																																																																				
40	GA	Assemble (2) D3197-041 as per Dwg D3197. (Note: D3197-1 is on BOM as material from Step 7) <b>Pick:</b> <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>4</td> <td>D2690-5</td> <td>Lanyard</td> <td></td> </tr> <tr> <td>2</td> <td>D3197-1</td> <td>Bar</td> <td></td> </tr> <tr> <td>4</td> <td>D3242-1</td> <td>Tag</td> <td></td> </tr> <tr> <td>12</td> <td>AN960JD10</td> <td>Washer</td> <td></td> </tr> <tr> <td>4</td> <td>DARS-004</td> <td>Pip Pin</td> <td></td> </tr> <tr> <td>4</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td></td> </tr> <tr> <td>4</td> <td>MS27039-1-24</td> <td>Bolt <del>Screw</del> #20429</td> <td></td> </tr> </table> <b>Identify as D3197-041</b>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	4	D2690-5	Lanyard		2	D3197-1	Bar		4	D3242-1	Tag		12	AN960JD10	Washer		4	DARS-004	Pip Pin		4	MS21042L3	Nut (or -3)		4	MS27039-1-24	Bolt <del>Screw</del> #20429																																								
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4	MS27039-1-24	Bolt <del>Screw</del> #20429																																																																							
41	QC5	Inspect work to Step 40																																																																							
42	KP	<b>Pick: Packing Kit (Note: D3195-041/-043, D3196-1/-3/-4 are on BOM as material from Steps 3-6, 35-36)</b> <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>2</td> <td>D3195-041</td> <td>Bracket</td> <td></td> </tr> <tr> <td>2</td> <td>D3195-043</td> <td>Bracket</td> <td></td> </tr> <tr> <td>1</td> <td>D3196-1</td> <td>Bar</td> <td></td> </tr> <tr> <td>1</td> <td>D3196-3</td> <td>Bar</td> <td></td> </tr> <tr> <td>1</td> <td>D3196-4</td> <td>Bar</td> <td></td> </tr> <tr> <td>2</td> <td>D3197-041</td> <td>Bar</td> <td></td> </tr> <tr> <td>4</td> <td>D3198-1</td> <td>Fitting</td> <td></td> </tr> <tr> <td>18</td> <td>D3215-041</td> <td>Harness Assembly</td> <td></td> </tr> <tr> <td>4</td> <td>D3215-043</td> <td>Harness Assembly</td> <td></td> </tr> <tr> <td>4</td> <td>AN4-5A</td> <td>Bolt</td> <td></td> </tr> <tr> <td>4</td> <td>AN4-13A</td> <td>Bolt</td> <td></td> </tr> <tr> <td>8</td> <td>AN4-20A</td> <td>Bolt</td> <td></td> </tr> <tr> <td>20</td> <td>AN960JD416</td> <td>Washer</td> <td></td> </tr> <tr> <td>12</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td></td> </tr> <tr> <td>8</td> <td>MS24694-S152</td> <td>Screw</td> <td></td> </tr> <tr> <td>2</td> <td>D3268-1</td> <td>Placard</td> <td></td> </tr> </table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	2	D3195-041	Bracket		2	D3195-043	Bracket		1	D3196-1	Bar		1	D3196-3	Bar		1	D3196-4	Bar		2	D3197-041	Bar		4	D3198-1	Fitting		18	D3215-041	Harness Assembly		4	D3215-043	Harness Assembly		4	AN4-5A	Bolt		4	AN4-13A	Bolt		8	AN4-20A	Bolt		20	AN960JD416	Washer		12	MS21042L4	Nut (or -4)		8	MS24694-S152	Screw		2	D3268-1	Placard				
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1	D3196-4	Bar																																																																							
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2	D3268-1	Placard																																																																							
43	QC4	Inspect Kit 100% for Completeness on the W/O																																																																							
44	PK	Identify and pack for shipping as per PPP D412-702-011 tuck K D3195-041	CL	05/10/05	30																																																																				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24/27
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b>	D3195-1 D412-702-011
04.02.23 <i>[Signature]</i>			
<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A1		<b>Qty:</b>	20 Kits
<b>Ref:</b> D412-702 Rev.A page 9			Page 4 of 4

Step	Location	Procedure	By	Date	Qty
45	AC	Cost / part 9.94	S45	05-10-06	30
46	DC	Close W/O 11.43 Inspect Level 21	<i>[Signature]</i>	05/10/06	30

Rev	Date	Change	Revised By	Approved
A	03.10.17	New issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

**RELEASED**  
04.01.08 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



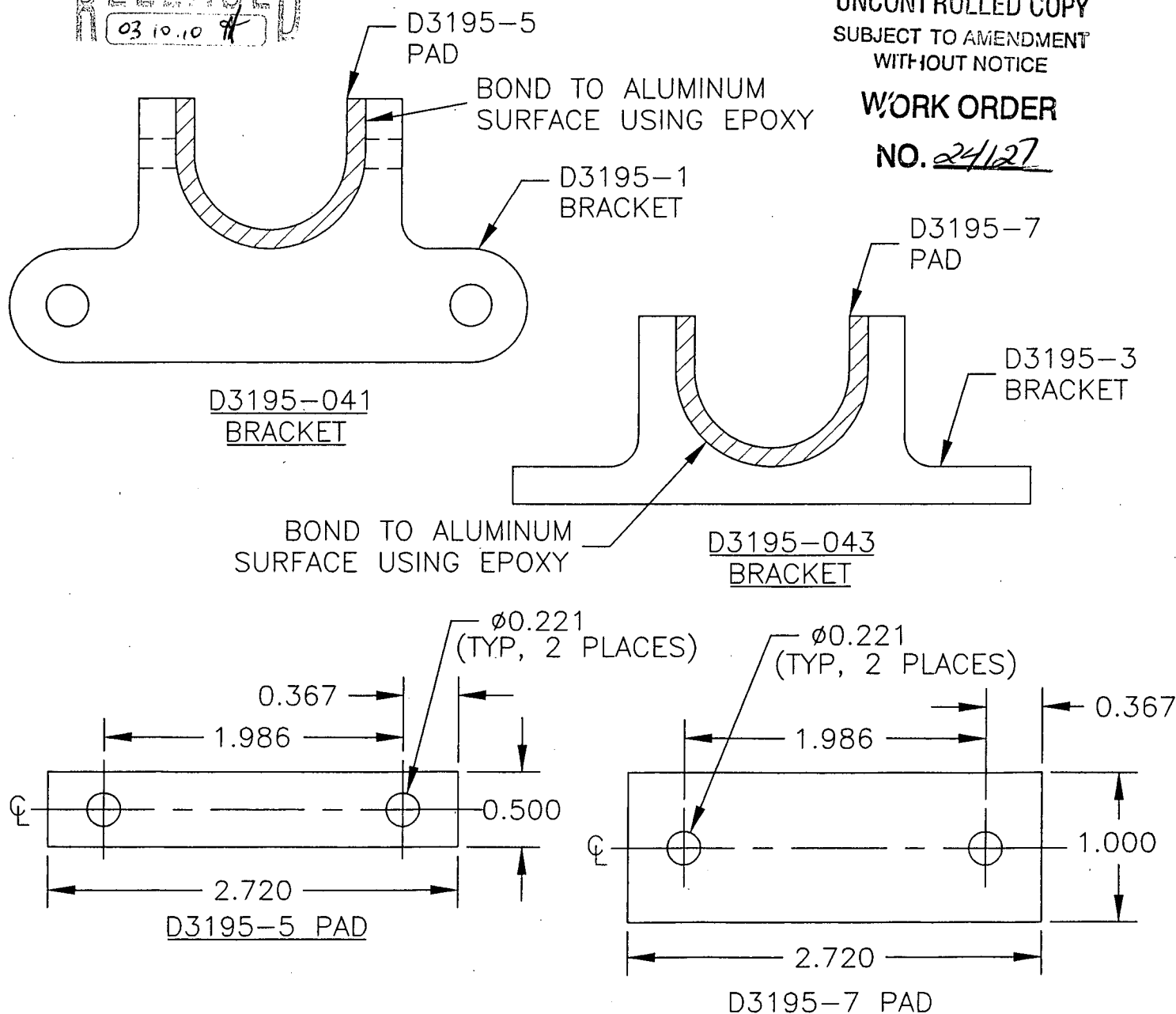


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE	SHOP COPY RETURN TO ENGINEERING

RELEASED  
03.10.10

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WITHOUT NOTICE

WORK ORDER  
NO. 24127



#### D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK  
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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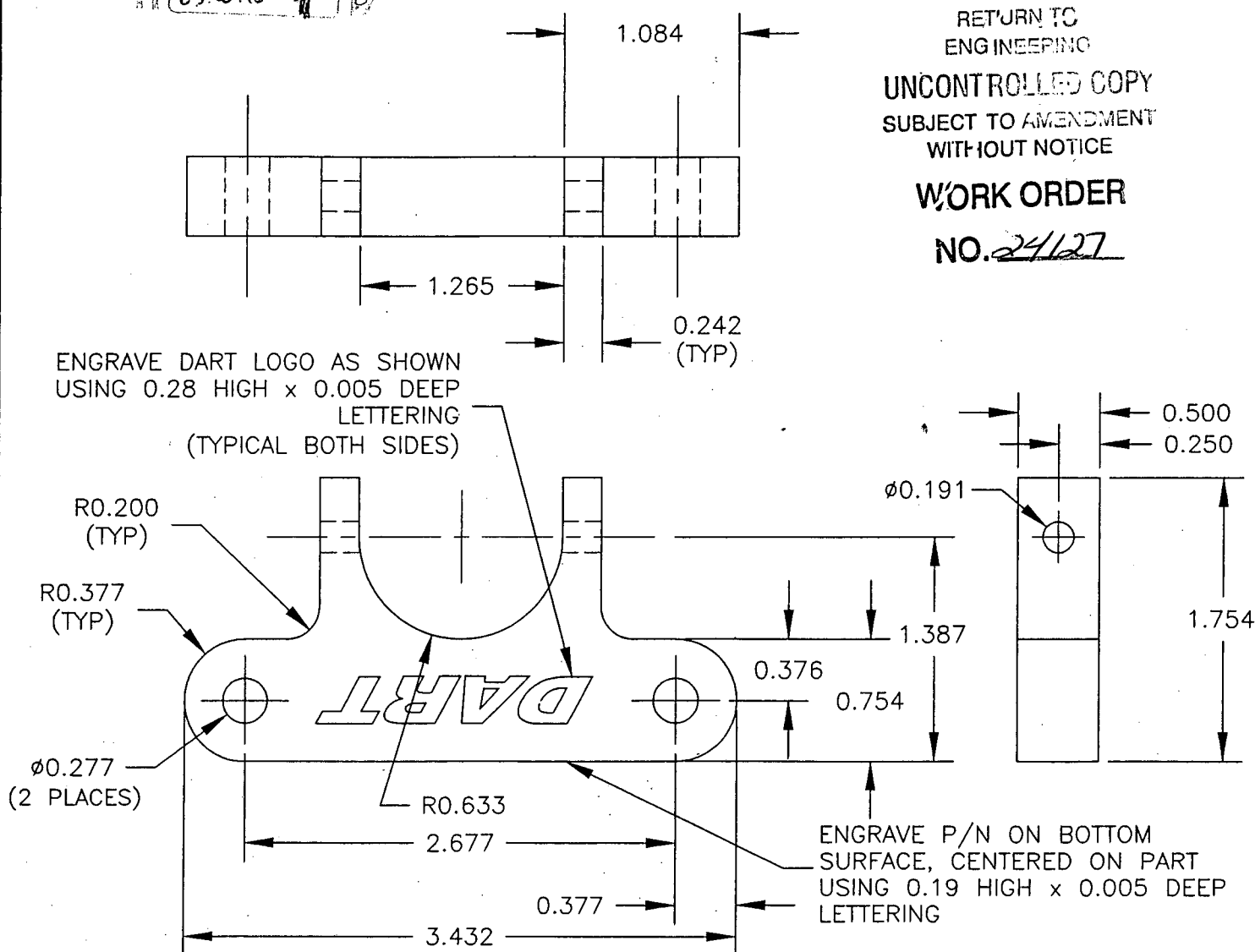
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

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03.10.10 *[Signature]*

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WORK ORDER  
NO. 24127



#### D3195-1 BRACKET

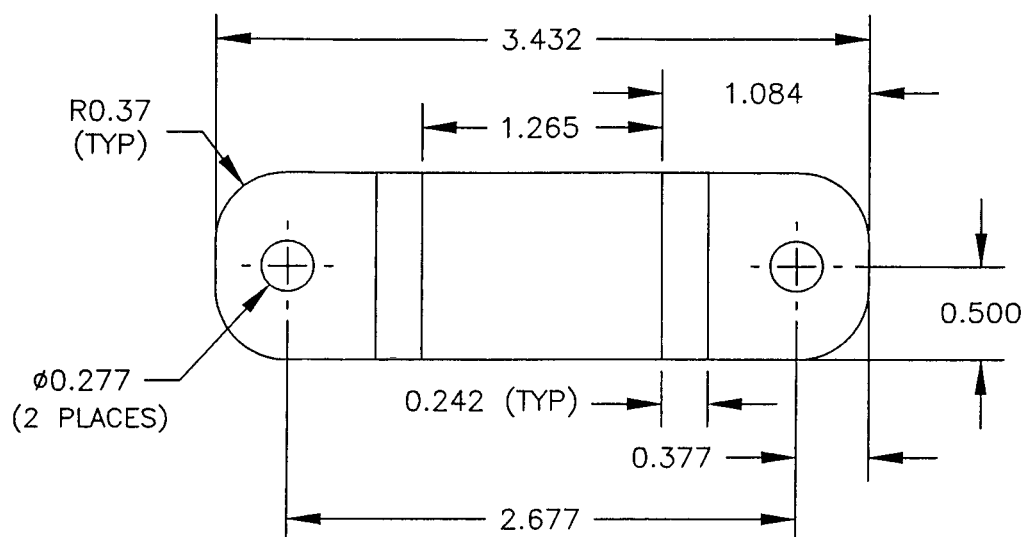
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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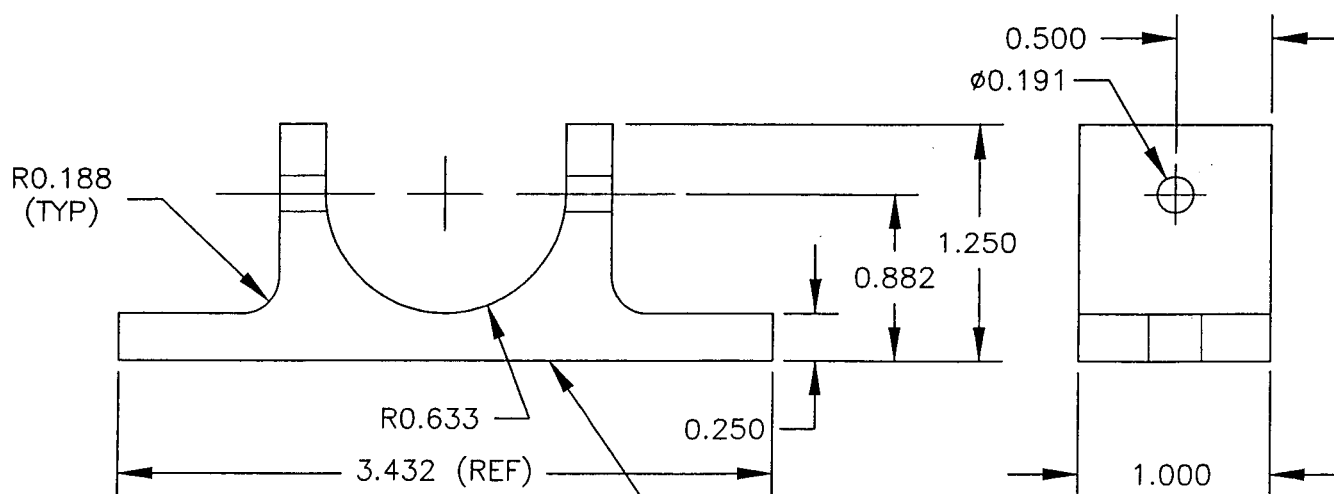
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



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WORK ORDER  
NO. 24127



RELEASED  
03.10.10

ENGRAVE P/N ON BOTTOM  
SURFACE, CENTERED ON PART  
USING 0.19 HIGH x 0.005 DEEP  
LETTERING

#### D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 30, 2005  
07:42 am

Work Order No : 0024127  
Project Name : D3195-1  
Project For : WK538  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3195-1  
Description : Bracket  
Manufactured : Yes  
Amount Req'd : 30  
Amount Done : 0  
Start Date : 08-29-05  
Est Finish Date : 09-21-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00